

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027707**Date Inspected:** 30-May-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 1200**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job site**CWI Name:** Ted Ilo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Skyway Bike Path Panel**Summary of Items Observed:**

This Quality Assurance Inspector (QAI), Dan Chang, arrived at jobsite at mentioned time to perform observation in work process by American Bridge/Fluor personnel Jason Collins, welder id # 8128, and Matt Chamberlain, foreman, along with monitor Quality Control Inspection functions by Quality Control Inspector (QCI), Ted Ilo.

This QA inspection observation is in response to CCO 179 which consist of mag drilling top and bottom (T&B) plates, installing 15/16" diameter conduit pipe sleeves, and welding the sleeves with 1/8" seal weld to the plates. Welding was performed by Jason Collins using Flux Cored Arc Welding (FCAW) process with E71T-8 .035" diameter electrode in accordance to Welding Procedure Specification (WPS) identified as ABF-WPS-D11-F2201, Rev. 0.

This QAI observed Quality Control Inspector (QCI), Ted Ilo, monitor T&B plates were ground and joint fit-up prior to welding. QCI also verified surface temperature using Fluke IR thermometer along with amperage and voltage using Fluke amp meter. QCI monitored welding parameters per WPS mentioned above. This QAI performed and verified welding and QC weld inspection at random interval and appeared to comply with contract documents.

Summary of Conversations:

No signifigication conversation regarding this observation during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

your project.

Inspected By:	Chang,Dan	Quality Assurance Inspector
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Reviewed By:	Levell,Bill	QA Reviewer
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